

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004343**Date Inspected:** 04-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Tai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the Tower.

**Heavy Shop 1**

The Quality Assurance Inspector observed ZPMC performing heat straightening operations on various tower skin plate and stiffeners components. The Quality Assurance observed ZPMC monitoring the temperature of the tower components with the use of a temperature indicating gun. The Quality Assurance Inspector observed the temperature of the heat straightening operations to be less than 650 degrees C. The Quality Assurance Inspector observed the following heat straightening request by ZPMC; 4606, 4084, 4713, and 4551.

**Heavy Shop 2**

The Quality Assurance Inspector observed ZPMC performing heat straightening operations on tower skin plate and longitudinal stiffeners on tower skin D and C east tower assemblies. The Quality Assurance observed ZPMC monitoring the temperature of the tower components with the use of a temperature indicating gun. The Quality Assurance Inspector observed the temperature of the heat straightening operations to be less than 650 degrees C. The Quality Assurance Inspector observed the following heat straightening request by ZPMC 4672 and 4673

**Summary of Conversations:**

No relevant conversations on this date.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lara,Raymond
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Wright,Mark
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QA Reviewer
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